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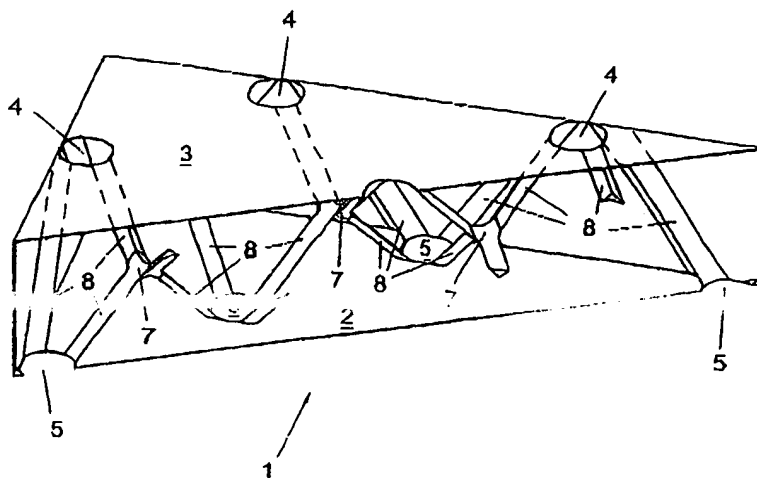
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- (71) Applicant (for all designated States except US): STICHT-
ING ASTRON [NL/NL]; Oude Hoogeteensedijk 4,
NL-7991 PD Dwingeloo (NL.).
- (72) Inventor; and
- (75) Inventor/Applicant (for US only): TROMP, Niels
[NL/NL]; Salkhof 51, NL-7908 AM Hoogetveen (NL.).
- (74) Agent: PRINS, A.W.; Nieuwe Parklaan 97, NL-2587 BN
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(54) Title: CONSTRUCTION ELEMENT, METHOD AND APPARATUS FOR MANUFACTURING A CONSTRUCTION ELE-
MENT, COMPUTER PROGRAM AND MIRROR

(57) Abstract: A construction element comprising: a first side with at least one first opening; a second side with at least one second opening; at least one first space between the first and second side connected to the first opening; at least one second space between the first and second side connected to the second opening and at least one connection between the first side and second side bounding the spaces at least partly. The first side, the second side and the connection form one integral whole.

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Title: Construction element, method and apparatus for manufacturing a construction element, computer program and mirror.

BACKGROUND OF THE INVENTION

The invention relates to a construction element. The invention also relates to an apparatus and a method for manufacturing a construction element.

5 From practice, construction elements are known which are hollowed out from one side. When hollowing out, upstanding walls are left in the element, thereby obtaining a light yet robust construction. After machining, the side from which the element has been hollowed out is virtually entirely open.

10 US patent 4,678,293, for instance, describes a reduced-weight mirror with a non-plane reflecting face. This mirror comprises a mass of optical material with cells obtained by milling at the rear face.

A drawback of these known construction elements is that they are not rigid. In particular with bending and torsional loads the known construction
15 elements are not rigid due to the virtually entirely open side. To obviate this drawback, it is known to close off the open side after manufacture, for instance by a flat plate. US patent 5,076,700, for instance, describes a lightweight mirror whose core and rear side are obtained from one single piece of glass. The core has been drilled from the front side, while walls are left for providing
20 rigidity to the core. At the rear side, the drilled parts can be provided with an opening for equalizing pressure differences. Also, at the rear side, mounting holes may be drilled. At the open front side, a front sheet with a reflecting
25 surface has been placed. However, closure of the open side has as a drawback that with the thus obtained closed element, the attachment of the flat sheet to the rest of the element forms a local weakening.

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SUMMARY OF THE INVENTION

It is an object of the invention to provide an improved construction element, in particular it is an object of the invention to provide a construction element that is light as well as rigid, in particular upon bending or torsional loading.

In order to achieve the stated object, the invention provides a construction element comprising: at least one first side with at least one first opening; at least one second side with at least one second opening; at least one first space between the first and second side, connected to the first opening; at least one second space between the first and second side, connected to the second opening and at least one connection between the first side and second side bounding the spaces at least partly, while the first side, the second side and the connection form one integral whole, and at least one of the spaces narrows towards the opening connected to it.

Such an element is light due to the presence of the first space and the second space. Also, due to the connection between the first and second side, a construction element according to the invention is rigid. Moreover, the first side, the second side and the connection form one integral whole, so that a construction element according to the invention has no local weakening.

The invention also provides in a mirror according to claim 24. In such a mirror, a construction element according to the invention can be advantageously used because in particular with mirrors, both light and rigid constructions are desired, in order to obtain a mirror which is optically as good as possible and which can easily be positioned.

The invention also provides a method according to claim 26. With such a method, a construction element according to the invention can be manufactured.

The invention also provides an apparatus according to claim 27. Such an apparatus is suitable for automatic manufacture of a construction element according to the invention. The invention also provides a data carrier

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provided with a computer program according to claim 29. With such a program, an apparatus according to the invention can be controlled.

Specific embodiments of the invention are laid down in the dependent claims. Further details, aspects and embodiments of the invention
5 are described hereinafter with reference to the examples in the Figures represented in the drawing.

BRIEF DESCRIPTION OF THE DRAWINGS

10 Fig. 1 schematically shows an example of an embodiment of an apparatus for manufacturing a construction element according to the invention.

Fig. 2 schematically shows a flow chart of an example of a method for manufacturing a construction element according to the invention.

15 Fig. 3 schematically shows a cross-sectional view of a part of an example of a construction element according to the invention in a stage of its manufacture.

Figs. 4a-c schematically show partly cutaway perspective views of examples of embodiments of construction elements according to the invention.

20 Figs. 5 – 17 schematically show perspective views of examples of embodiments of a construction element according to the invention.

DETAILED DESCRIPTION

25 In Fig. 1, an example of an apparatus according to the invention is shown. The example shown is a multiaxial machining apparatus and, more specifically, a five-axis milling apparatus 100. A five-axis milling apparatus is known per se, for instance from US patent publication 5,669,867. The milling apparatus 100 comprises a frame 106 with a holder 101 for a workpiece 102
30 and a cutter 112. The holder 101 and cutter 112 are movable relative to each

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other. In the example shown, the holder 101 can rotate about a rotation axis 103 relative to the frame 106. The cutter 112 can move in horizontal and vertical direction relative to the frame 106, as is indicated with the arrows 104 and 105. The rotation axis 103 is at an angle with respect to the plane of the holder 101 on which the workpiece 102 lies. The angle of the workpiece 102 relative to the cutter 112 can be varied by rotating the holder 101 about the axis 103, as is known from US patent publication 5,669,867.

The rotation of the holder 101, the movement of the cutter 112 and the cutter 112 are driven by drive units 108 – 111, for instance electric motors, which are communicatively connected to a central control apparatus 107. The control apparatus 107 is provided with control units 1071 – 1074 for driving the milling apparatus 101 via the drive units 108 – 111. In the example shown, each of the control units 1071 – 1074 is arranged for converting instructions coming from a central control unit 1075 into drive signals for the respective unit 108 – 111. The central control unit 1075 sends instructions such that, during machining, the workpiece is positioned in a suitable manner by the drive units 108 – 111 and their associated control units 1071 – 1075, so that the desired processing is carried out.

With the apparatus such as the five-axis milling apparatus 100 it is possible, by tilting and rotating, to place the tool 112, for instance a cutter, in virtually any orientation and position relative to the workpiece 102. In the examples shown of an apparatus or method according to the invention, cavities or spaces are made in a workpiece from two or more sides, for instance by cutting and/or grinding the workpiece. The workpiece can then be machined into a construction element according to the invention such that via small openings a relatively large internal volume is removed from the workpiece so that relatively large spaces are formed in the workpiece.

The milling apparatus 100 can carry out a method according to the invention with great precision. However, a method according to the invention can also be carried out with different means, such as, for instance, by hand. In

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Fig. 2, schematically, a flow chart is shown of an example of a method according to the invention. In a first step 200 on a first side of the workpiece an opening is provided. Then, in a second step 201, from the opening on the first side, the workpiece is hollowed out further. In step 202, a second opening is provided on a second side of the workpiece, and in step 203 the workpiece is hollowed out from the second opening too. As a rule, the second side is located opposite the first side, this is, however, not strictly necessary. As indicated in Fig. 2 with the arrows 204 - 207, after the removal of the material on one side, a next opening can be provided and to that end, step 200 or 202 can be carried out again or an opening can be provided on the other side. It is then also possible to machine the workpiece from both sides at the same time.

The steps of the example of a method according to the invention illustrated by the flow chart of Fig. 2 can also be carried out in a different order. For instance, it is possible to first provide a first opening in a first side and thereupon, or simultaneously, provide a second opening in a second side and to subsequently hollow out the workpiece via the first opening and then via the second opening or, first, via the second opening and then via the first opening or from both openings at the same time.

A method according to the invention can for instance be utilized in materials to be cut or ground. With a method according to the invention, good overall tolerances are attainable, since a method according to the invention can lead to a reduction of parts: for instance no separate cover plate is required for obtaining a good rigidity. A reduction of parts then leads to a reduction of the number of potentially relatively inaccurate transitions between parts, so that the overall accuracy increases.

When machining materials with high internal stresses, removal of material may lead to deformations of the product. With a construction element according to the invention, due to the connection between the sides, such a possible deformation is reduced. In addition, the construction element can be designed so as to have a high degree of symmetry, such as for instance in the

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example of Figs. 16A – B. A favorable effect of this is a well-balanced removal of material from two sides. As a result, the deformation which has occurred after machining one side will be somewhat reduced after machining the second side. These two effects combined lead to a further increase of the overall accuracy.

It is also possible, for instance, to dispense with adjustment mechanisms for fine-tuning since the whole is sufficiently accurate due to the increased overall accuracy. This reduces *inter alia* the number of parts, the weight and the testing and alignment time.

Moreover, a method according to the invention offers a large design choice, because for a given workable volume a more rigid and/or lighter part can be manufactured. This yields a further enlargement of the freedom in designing other parts which, one way or the other, have a relation to the construction element according to the invention.

Also, a construction element manufactured with a method according to the invention has relatively few assembly parts and a relatively short assembly time due to the limited number of components and the possibility to, for instance, dispense with adjustment mechanisms for fine-tuning. The local rigidity of a construction element according to the invention can be increased in several ways, such as by changing the internal structure, for instance by leaving additional reinforcement ribs in the space or spaces at the inside of the side(s) with the opening(s). To that end, the external structure also can be adapted, for instance by increasing the local thickness.

Fig. 3 shows an example of a manner in which the workpiece can be hollowed out from two sides, located opposite each other in this example, and can be formed into a construction element according to the invention. From a first opening 111 at first side 3 of the workpiece 1, a space 6 has been provided with a machining element 112, in this example a cutter, by hollowing out the workpiece from a first opening 4 with a cutter or other tool. From a second side

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2, via a second opening 5 too, the workpiece 1 is hollowed out with a cutter 112.

In the example shown, the angle of the cutter 112 relative to the surfaces on the first and second side 2, 3 is varied while the respective opening, however, is not significantly enlarged. As a result, the construction element has a low weight, while the surfaces remain largely intact. In the example, to that end, the cutter 112 is pivoted about a pivot located in or adjacent the original surface of the workpiece at the location of the opening 4 or 5, respectively. Thus, via a small opening, a large amount of material can be removed from the workpiece 1. The openings 4, 5, respectively, in the surfaces 2, 3 of the workpieces form a constriction of the spaces 6. Also, the tool 112 is held at an angle to the respective surface 2, 3, so that adjacent the surfaces 2, 3, apart from the openings 4, 5, no material is removed and the surfaces 2, 3 have remained virtually intact.

In the example in Fig. 3, in the workpiece, conical spaces are provided; the spaces 6 are bounded by a substantially flat base 61 and the plane that is formed by the generatrices 8 of the points of a closed curve located in the base surface 61 bounding the base surface and a point outside the base. In the example shown, this point is adjacent the respective openings in the surfaces 2, 3 of the workpiece 1. In the example shown, the flat base 61 is obtained by also varying, when pivoting, the extent to which the cutter 112 is inserted into the workpiece. Both the base and the generatrices can have any desired shape and position. In a construction element according to the invention, the spaces can also have a different shape, such as for instance spherical, cubic or otherwise.

With the construction element, according to the invention, the weakening of the element is prevented as much as possible in that the sides with the openings are virtually completely intact. Only the entrance openings for the tool, in Fig. 3 the openings 4, 5, interrupt the respective surfaces.

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A construction element according to the invention can be very rigid, in particular upon bending or twisting. Depending on the wall thickness, bottom thickness and the specific manner of use of the invention, simulations have shown that a construction element according to the invention is at least
5 twice as rigid as the known elements with the same self-weight.

A construction element according to the invention can also be light in weight, inter alia because due to the connection remaining intact between the sides, relatively thinner walls and ribs suffice. It has, for instance, appeared that in aluminum, as a rule, a wall thickness to 0.3 mm is well
10 attainable with a construction element according to the invention. It has also appeared that with a construction element according to the invention light weighting percentages of less than 5% are attainable, while with the known traditional construction elements often a percentage of more than 20% is attainable. The light weighting percentage then indicates how much volume of
15 material the construction element has in comparison with the volume of the entire construction element.

Also, due to the combination of high rigidity and low weight, a construction element according to the invention has a high eigenfrequency, so that, in use, few or no undesired vibrations occur in the construction element.
20 Consequently, a construction element according to the invention can be applied in uses wherein many vibrations occur, such as, for instance, in the vicinity of combustion engines. Furthermore, a higher rigidity with the same weight leads to less bending and a lower amplitude of possible vibrations induced during the manufacturing process according to the invention so that
25 the surfaces of the construction element can be of smoother and more accurate design.

A construction element according to the invention is manufactured from one single part and therefore forms a homogenous or monolithic entity. Consequently, a construction element according to the invention is particularly
30 suitable to be used under extreme conditions such as cryogenic conditions,

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high temperature or vacuum uses, because the entire element reacts in the same manner to extreme conditions. Moreover, since it contains little material, a construction element according to the invention can have a good heat transfer and a short cooling down and/or heating up cycle, so that such a construction element according to the invention rapidly and readily adjusts and for instance stresses in the material as a result of temperature differences are prevented.

A construction element according to the invention can also be used in, for instance, optical or aeronautical uses, such as, for instance, in telescopes or frameworks for airplanes or space crafts. A construction element according to the invention can also be used in the semiconductor industry. In particular in so-called wafer-steppers, it is of importance that the carrier ('stepper') on which a thin slice of semiconductive material ('wafer') lies, can be positioned rapidly and with great precision. A construction element according to the invention can then be advantageously used, so that the carrier, as a result of the low weight, can be accelerated or decelerated in a short period of time and, as a result of the great rigidity, can be accurately placed. Similar advantages can also be obtained in other uses in which high accelerations/decelerations of products occur, such as, for instance, in mechanisms or robots, machining apparatus, measuring machines, 'pick-and-place'-mechanisms such as component placing machines and 'wire-bonders', as well as for printers and other professional motion machines.

Furthermore, in a construction element according to the invention, cables and ducts can simply be arranged through the openings in the construction element, in particular if the spaces in the element are interconnected.

In Fig. 3, the spaces 6 are separated from each other by a connecting element 8 connecting the surfaces 2, 3 to each other. In Fig. 3, the connecting element 8 is a wall separating the two adjoining spaces 6. It is also possible that the spaces overlap to a greater or lesser extent. Overlap can be expressed

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in a percentage and can vary between 0 and 100%. This can occur in two directions: X and Z, as indicated with the arrows X, Z in Fig. 3. The X-direction is then in the imaginary plane which is at an equal distance from the two surfaces from which the workpiece is hollowed out. In Fig. 3, this plane is parallel to and at an equal distance from the surfaces 2, 3 in which the openings 4, 5 are located. The Z-direction corresponds to the normal of that plane. The normal of the X-direction which runs through the center of the respective entrance opening 4, 5 of the spaces 6 is the central cavity axis, indicated in Fig. 3 by the dotted lines CA1 and CA2.

The overlap in X-direction is defined as the ratio between the distance or angle between the central axes of two adjoining cavities relative to the imaginary distance or angle at which the first cavity and the adjoining cavity exactly touch each other. When the cavities exactly touch there is 0% overlap; when the cavities coincide, an overlap of 100% is involved. The extent of overlap in the Z-direction is defined as an extent to which the central cavity axes of two adjoining cavities projected on the X-direction coincide. In Fig. 3, when projected in the X-direction, the central cavity axes overlap each other partly but not completely, and therefore there is an overlap in the Z-direction of less than 100%.

In Figs. 4A – 4C, examples of spaces and the connections between the surfaces 2, 3 are shown. In Fig. 4A, a cavity in the middle of a construction element 1 according to the invention is shown, while in Fig. 4B, the cavities near the sides of a construction element 1 are visible. In Fig. 4C, a cavity near the corners of a construction element according to the invention is visible. In Fig. 4A, an example is shown of a construction element, where the cavity between the first side 2 and second side 3 is a pyramid with a square base 61, as is indicated in dotted lines. The top of the pyramid is omitted because this is formed by the entrance opening 4 for the tool. That is why, strictly speaking, the space bounded by the pyramid has the shape of a truncated pyramid or of a truncated cone with a rectangular base. The pyramidal cavity

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is in communication with other cavities in the construction element which cavities are not shown in Fig. 4A. The pyramidal cavity is bounded by connections 81 - 84 between the first side 2 and the second side 3. Here, the connections form the ribs of the pyramid. In the example of Fig. 4B, the connections 81 - 87 bounding the pyramidal cavities are at the edge of the construction element 1. There, the connections 81 - 84 form the ribs of a pyramid with a base forming a non-square rectangle. The connections 85 - 87 form the ribs of a pyramid with a triangular base. In Fig. 4C, connections 82 and 87 form a rib of the construction element and connections 81 - 84 and 85 - 87, respectively, form pyramids, which form a corner of the construction element.

In Figs. 4A - 4C, the connections 81 - 84 form the ribs of a pyramid, but the connections between the first side and the second side can also be designed differently and, for instance, form the faces of the pyramid and be interconnected, so that the space bounded by the pyramid is separated from other spaces in the construction element and that, therefore, the spaces have 0% overlap in the X-direction.

Broadly speaking, all spaces or cavities in a construction element according to the invention can be described as variants of a pyramid or a different cone-shape. Variants can, for instance, be made by changing the base surface, for instance by designing the base to be not flat but curved. Also, the shape of the edges of the base can, for instance, be straight or curved or a combination thereof. Also, the generatrices and hence the interior of the pyramid can be designed in any suitable manner, for instance, generatrices can be curved so that the walls of the pyramid or the cone are concave, convex or a combination thereof. The spaces in a construction element according to the invention can be manufactured with several tools. For instance, one cavity can be made with several, different tools and hence have several sorts of roundings.

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In Figs. 5 – 15, examples are shown of shapes of construction elements according to the invention. Naturally, the invention is not limited to the shapes shown. In Figs. 5, 6 and 7, a construction element is shown with one of the surfaces, in these Figures the second side 2, of curved design. In Fig. 5, the second side has one convex curve, while in Fig. 6, the second side has a concave curve. In Fig. 7, the side 2 is multi-curved.

Fig. 8A shows a perspective view of a strip-shaped construction element according to the invention. Fig. 8B shows a cutaway view of the strip-shaped construction element. What is special about the spaces in the strip-shaped construction element is that the base surface of the pyramid or conical spaces is a rectangle whose width is equal to the width of the entrance opening. Overlap of cavities is possible, even to such an extent that the internal ribs disappear. If the width of the base surface of the cavity in a strip is larger than the tool diameter, and the width of the entrance opening remains minimal, then, the internal structure will resemble more that of a beam. The strip is in fact a special variant of a beam. As shown in Fig. 9A and 9B, the side surfaces 9, 10 of the strip can be curved and endless, so that the construction element can, for instance, be conical or funnel-shaped.

Fig. 10 is an example of a construction element according to the invention shown with a composite pyramid shape. The element in Fig. 10 is formed by two pyramidal recesses with 100% overlap in X-direction and more than 0% overlap in Z-direction. Here, first, from two opposite sides, a pyramidal space is provided in a workpiece via the openings 4, 5, whereupon at the outside of the recess, further material has been removed, so that only the connections 8, in the example the inclining walls of the pyramids, have remained.

In Fig. 10, the Z-overlap is smaller than 100% and the bases 13, 14 of the pyramids do not coincide with the walls in which the openings 4, 5 have been provided. Naturally, the overlap can also be 100%, so that the bases 13,

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14 coincide with the sides in which the openings 4, 5 lie. The Z-overlap can also be 0%, so that the bases 13, 14 coincide and form a partition wall.

With the construction element according to the invention shown in Fig. 10, as is the case with the other examples, the shapes of the spaces in the element can be varied. For instance, the spaces can have a hexagonal base with at least partly vertical walls in upstanding relation thereto and have 100% overlap in X- as well as in Z-direction, so that a honeycomb-shaped construction element is obtained, as is shown, for instance, in Fig. 13. Also, from the faces of the pyramid, material may have been partly removed so that, for instance, only ribs of the pyramid are present, as is the case in the example of Fig. 15.

It is also possible to design the construction element to be spherical. A sphere can be understood to be a special variant of the multiple pyramid. A spherical construction element can then be manufactured by hollowing out two pyramid cavities, the pyramids having a circular base and concave inner wall and being located opposite each other. When the overlap in the X-direction is 100% and the overlap in the Z-direction minimally 0%, no effective bottom surface remains and a spherical space is obtained. The sphere can then also be provided with more openings in the surface so that, while utilizing the same tool, the diameter of the sphere can be enlarged.

Fig. 11 shows a tubular example of a construction element according to the invention. A tube can be understood to be an assembly of several strip-shaped elements as shown, for instance, in Figs. 8A and 8B. The tube can vary in cross section as well (circle, polygon, etc.) and for instance taper lengthwise. In one wall of the tube, the cavities have no overlap in the X-direction but between two adjoining walls, intersection between cavities occurs. Through a combination of the tube and the method of hollowing out as used with a sphere, also a pipe-shaped element, i.e. an element with a circular cross section, can be obtained.

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In Figs. 12A and 12B, a disc-shaped element is shown. The disc-shaped element 1 has a front wall 10 and rear wall 2. In the example shown, the front and rear wall 2, 10 are multi-curved in the same direction, i.e. in Figs. 12A and 12B, the concave side of the rear wall 2 is directed towards the convex side of the front wall 10. It is also possible to design a disc-shaped element such that, for instance, the convex sides of both walls are directed towards each other or away from each other. In the latter case, the disc-shaped element can for instance be discus-shaped. Such an element can be manufactured by combining a spherical element and an element with curved strip-shape such as, for instance, the construction element in Figs. 9A-9B. In the disc-shaped element in Figs 12A-B, via openings 4 on the edge of the disc, radial spaces are provided, separated from each other by ribs 8. The ribs 8 of the disc-shaped element can be considered as several I-profiles, extending in radial direction from the opening 5 in the rear wall 2 towards the edge of the disc. However, the ribs can also have a different shape and, for instance, extend in a spiral shape from the center of the disc towards the edges. The overall direction is radial, but the ribs need not expressly be straight. The disc-shaped element is also hollowed out via the opening 5 in the rear wall 2. In the example shown, the element is hollowed out via a single opening 5, but it is also possible to hollow out the element via several openings in the back wall. The spaces between the ribs 8 have a passage 12 to the opening 5 where the spaces meet.

The disc-shaped element can be used for optical applications, for instance as a very rigid and light mirror. With the known mirror constructions, in optical-mechanical designs, a mirror is attached to a base plate. A drawback thereof is, inter alia, that additional heat resistance occurs due to the limited contact surface between both parts, in particular with cryogenic uses. With a construction element according to the invention, it is possible to join the functions of the mirror and base plate by providing the element with a mirroring or reflecting surface, in the example of Figs. 12A-B, for instance, the

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surface 10 or the surface 2 can be designed to mirror by, for instance, polishing it. By joining both functions, the heat resistance is, at least partly, reduced. As a result, the optical accuracy of the mirror increases too. The mirror surface can then be concave, convex or planar. The sides with openings too can be
5 provided with a mirroring surface.

It is possible to provide the disc-shaped element with an upstanding edge (rib), as indicated in the example of Fig. 17 by reference numeral 15. Due to the upstanding edge 15, the rigidity of the hollow side 10 of the disc-shaped element is increased, which is suitable, in particular when used as a mirror,
10 since optical deviations in the mirror are reduced as a result thereof.

As described hereinabove, the cavities or spaces in a construction element according to the invention can have any desired shape. For instance, the spaces can be designed having a honeycomb-shape, as shown in Fig. 13, by providing spaces with a hexagonal base and at least partly vertical walls from
15 the first side and the second side, while the spaces have a 100% X-overlap and more than 0% Z-overlap. Also, between the first side 2 and second side 3, one continuous space can be formed in which connecting beams extend forming ribs of pyramids, as in Fig. 15. In Fig. 15, from the openings 4, 5 pyramids with a rectangular base have been hollowed out with an X-overlap of just over
20 0%, such as less than 5% and a Z-overlap of almost 100%.

For, for instance, the attachment of other structures to a construction element according to the invention, the local rigidity can be increased. For instance, a higher local rigidity can be obtained by reducing the base surface of the cavities and thus obtaining a larger number of cavities.
25 Also, all or local internal walls/ribs can be designed to be thicker by increasing the mutual distance in X- and Z-direction between the cavities. Also additional internal and/or external ribs can be added or one of the surfaces of the element can be designed to be thicker locally, or entirely. Also, the shape of the surfaces of the element can be varied, such as for instance concave or
30 convex.

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As shown in Fig. 14, also, internal partitions 801 can be added, designed as left-behind material of the workpiece. The partitions ensure a local increase of strength and rigidity. Also, due to the partitions, the overall strength and rigidity of the construction element according to the invention
5 can be increased. As a result, it is possible, as in the example of Fig. 14, to transfer a load on, for instance, the points A-C to four other points. In the example of Fig. 14, the partitions 801 are internally inside the workpiece and run from the three attachment points A-C on the top side to attachment points (not shown) at the corners of the construction element 1, three corners D-F of
10 which are shown in Fig. 14. In the example shown in Fig. 14, for instance the weight of a product attached to the attachment points A-C can be transferred by the partitions 801 to the four corner points of the element so that, locally, at the intersections of the partitions, the rigidity is increased without adding much mass, while, also, the overall rigidity increases.

15 The walls, and partitions, if any, of a construction element according to the invention can be provided to a greater or lesser extent with openings. Besides being planar, the sidewalls can then also be single and/or multi-curved. Also, the sidewalls can differ in thickness locally, for instance in that material is internally and/or externally added or removed. Also, the spaces in a
20 construction element according to the invention can be filled with, for instance, an insulating material or a gas. If the spaces are mutually connected, these can also serve as channels for, for instance, a coolant. Naturally, in this latter case, the openings should be closed off.

In Figs. 16A-B, an example of a construction element according to
25 the invention is shown wherein in the first and second side 2, 3, respectively, adjacent the opening 4, 5, a groove 16 is provided, extending, in this example, around the respective opening. Due to the groove, more space for the processing element is obtained at the respective side, so that this can be brought at a more inclined angle into the opening 4, 5. Also, due to the groove,
30 the local rigidity of the surface of the respective side is increased, which can be

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of use, for instance when attaching other parts to the construction element.
The example shown is particularly suitable for use with isostatic suspensions.

The example of a construction element according to the invention of Fig. 16B comprises several units as shown in Fig. 16a. The unit shown in Fig. 16A has three ribs 8 interconnecting the first and second side 2, 3. The number of ribs may vary: from 0 to indefinite, i.e. a honeycomb-shaped connection. In practice, the number will mostly be between three and six. In the example shown, the X-overlap of the space manufactured via the first opening and the space manufactured via the second opening is 100% and the Z-overlap is almost 100%.

It is noted that the invention is not limited to the examples described hereinabove. After having read the foregoing, the variants will be self-evident to the skilled person. It is, for instance, possible to provide the first and/or the second opening at an edge or corner of the construction element.

It is also noted that the term "comprising" does not exclude that, in addition to the elements mentioned, other elements are present.

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Claims

1. A construction element, comprising:
at least one first side with at least one first opening;
at least one second side with at least one second opening;
at least one first space between the first and second side which is connected to
5 the first opening;
at least one second space between the first and second side which is connected
to the second opening and
at least one connection between the first side and second side which bounds
the spaces at least partly.
10 wherein the first side, the second side and the connection form one integral
whole and at least one of the spaces narrows towards the opening connected to
it.
2. A construction element according to claim 1 or 2, wherein at least
one of the spaces is conical or pyramidal.
- 15 3. A construction element according to claim 1 or 2, comprising: at
least two beam-shaped connections between the first and second side, which
bound the spaces at least partly.
4. A construction element according to claim 3, wherein the beam-
shaped connections form generatrices of a cone or ribs of a pyramid.
- 20 5. A construction element according to claim 3 or 4, wherein the beam-
shaped connections also form ribs of the construction element.
6. A construction element according to any one of the preceding claims,
wherein the first space and the second space overlap at least partly.
7. A construction element according to any one of the preceding claims,
25 wherein less than 10% of the surface of the first side is formed by openings.
8. A construction element according to any one of the preceding claims,
wherein less than 10% of the surface of the second side is formed by openings.

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9. A construction element according to any one of the preceding claims, wherein the spaces comprise at least 50% of a volume of the construction element located between the first side and second side.
10. A construction element according to any one of the preceding claims, wherein the spaces comprise 90% of a volume of the construction element located between the first side and second side.
11. A construction element according to any one of the preceding claims, wherein the first side and the second side are at a distance from each other.
12. A construction element according to any one of the preceding claims, wherein the first side is not parallel to the second side.
13. A construction element according to any one of claims 1 – 13, wherein the first side and the second side are substantially parallel.
14. A construction element according to any one of the preceding claims, further comprising:
- 15 at least one side surface between the first and the second side.
15. A construction element according to any one of the preceding claims, wherein at least one of the side surfaces or sides is at least partly curved.
16. A construction element according to claim 14, wherein at least one of the side surfaces or sides is single-curved.
- 20 17. A construction element according to claim 14, wherein at least one of the side surfaces or sides is multi-curved.
18. A construction element according to claim 14 and one or more of claims 1 – 16, wherein the surface of at least one of the first and second sides is annular and between the sides, a first side surface and a second side surface
- 25 are present.
19. A construction element according to claim 18, wherein the diameter of the annular first side is greater than the diameter of the annular second side.

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20. A construction element according to claim 15 and one or more of claims 1 – 19, wherein the first side surface and the second side surface have a greater surface than the first side or the second side.
21. A construction element according to any one of the preceding claims, wherein at least one of the side surfaces is disc-shaped.
22. A construction element according to any one of the preceding claims, with a spherical element surface comprising the first side and second side.
23. A construction element according to any one of the preceding claims, which is, at least partly, of aluminum.
- 10 24. A mirror, comprising a construction element according to any one of the preceding claims, at least one side or surface of which is a reflecting surface, at least partly.
- 15 25. A mirror according to claim 24, wherein the construction element is a construction element according to claim 20 and one of the disc-shaped side surfaces comprises a reflecting surface.
26. A method for manufacturing a construction element according to any one of claims 1 – 25 from a workpiece with at least a first side and at least a second side, the method comprising:
- providing a first opening in the first side;
 - 20 - removing material, at least partly, located between the first and second side via the first opening, so that a first hollow space is obtained in the workpiece;
 - providing a second opening in the second side and
 - removing material, at least partly, located between the first and
 - 25 second side via the second opening, so that a second hollow space is obtained in the workpiece;
 - wherein the removal of material is carried out such that between the first side and second side at least one connecting element is formed bounding the spaces at least partly and at least one of the
 - 30 spaces narrows towards the opening connected to it.

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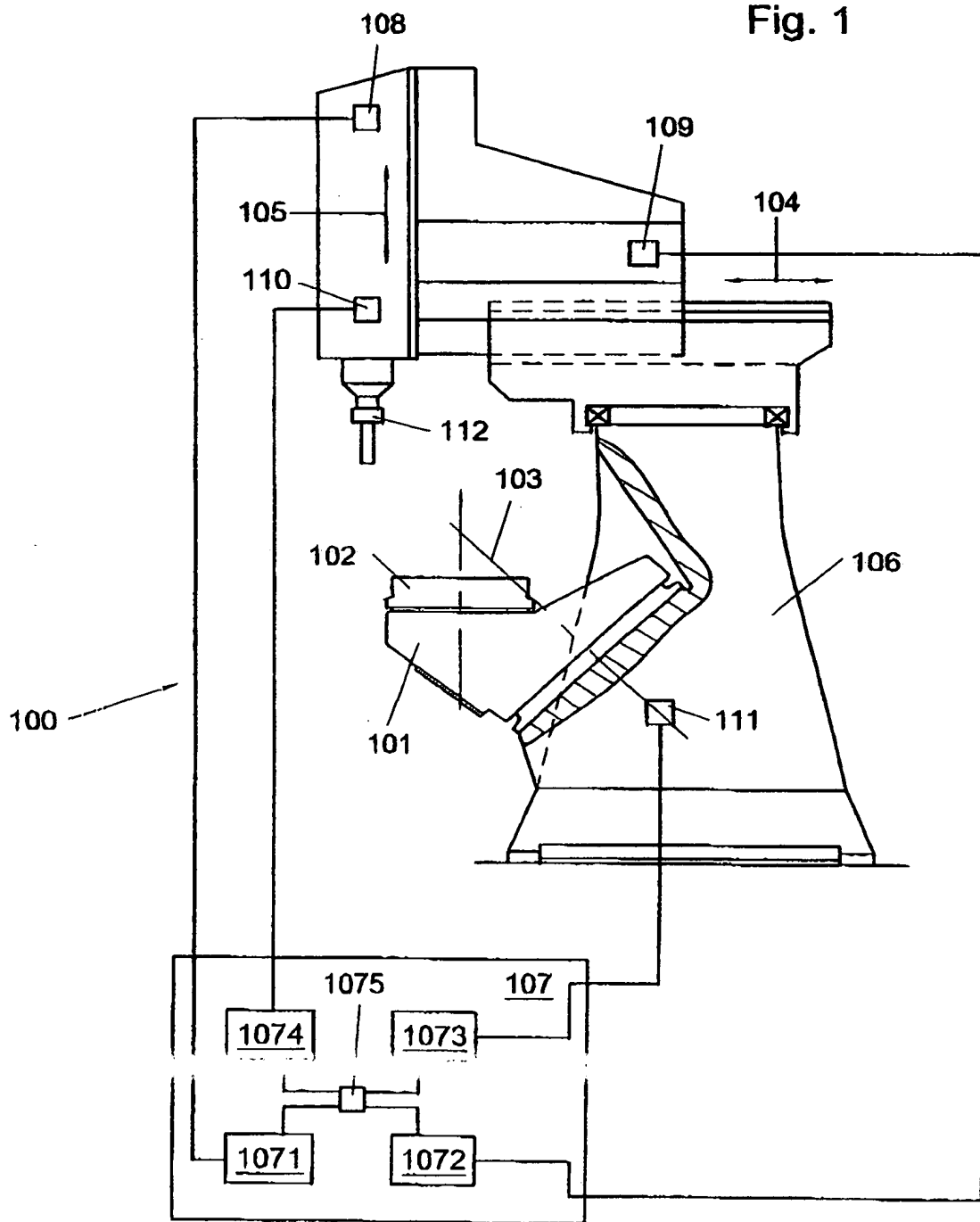
27. An apparatus for manufacturing a construction element according to one or more of claims 1 – 25, comprising
at least one machining element; and
at least one holder for at least one workpiece and
- 5 at least one control apparatus for driving the at least one machining element and the at least one holder, wherein the at least one control apparatus comprises at least units for:
providing at least a first opening in a first side;
removing material, at least partly, located between the first and a second side
- 10 with the at least one machining element via the at least one first opening, so that at least a first hollow space is obtained;
providing at least one second opening in a second side and removing material, at least partly, located between the first and second side with the at least one machining element via the at least second opening, so that at least a second
- 15 hollow space is obtained; the arrangement being such that at least one of the spaces narrows towards the opening connected to it.
28. An apparatus according to claim 27, wherein at least one of the at least one machining elements comprises a multiaxial milling apparatus.
29. A data carrier provided with data representing a program loadable
- 20 in a programmable apparatus, which program comprises program code for carrying out one or more steps of a method according to claim 26 with an apparatus according to claim 27 or 28.

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Fig. 1

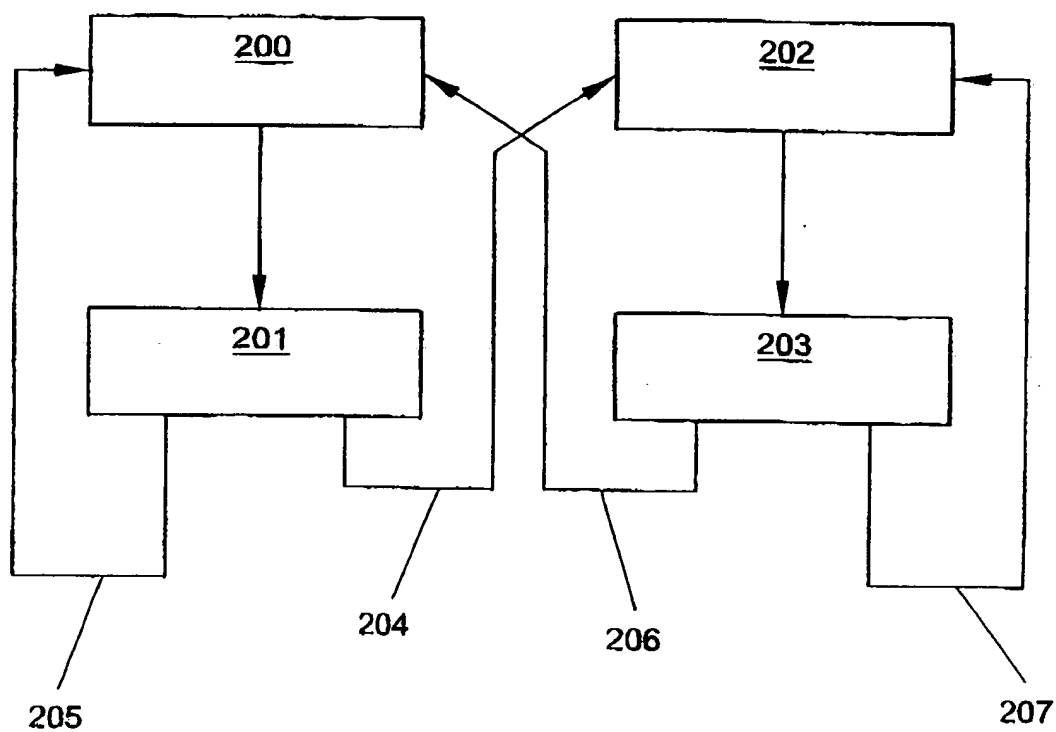


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JC20 Rec'd PCT/PTO 27 APR 2005**Fig. 2**

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Fig. 3

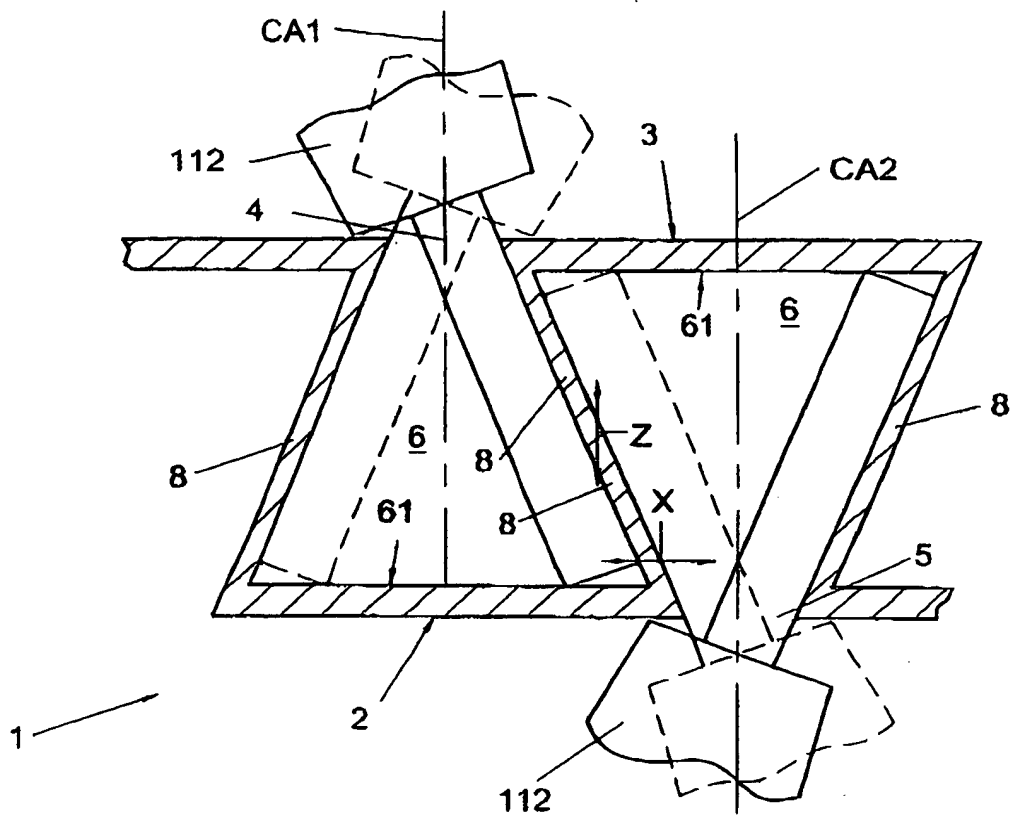
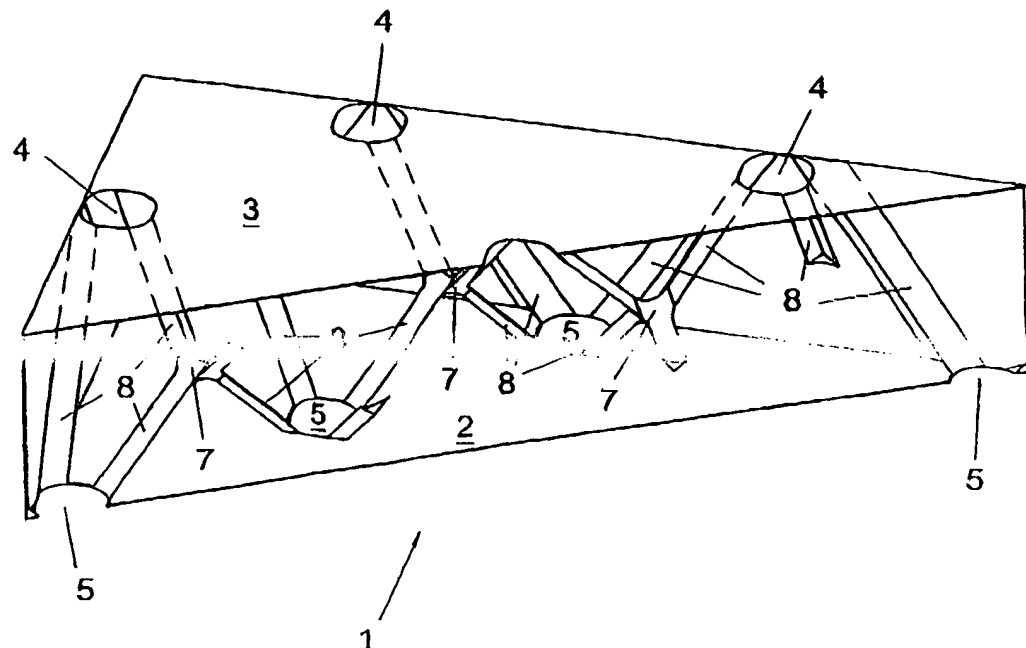


Fig. 15



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Fig. 4A

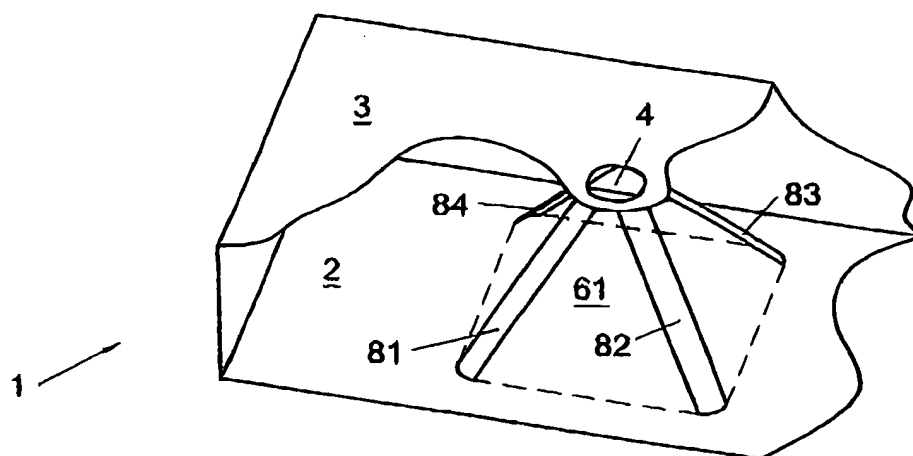


Fig. 4B

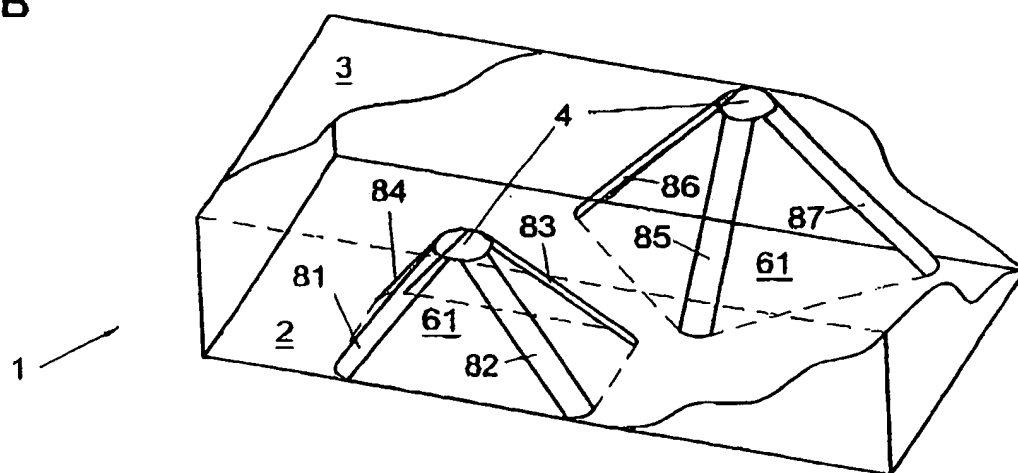
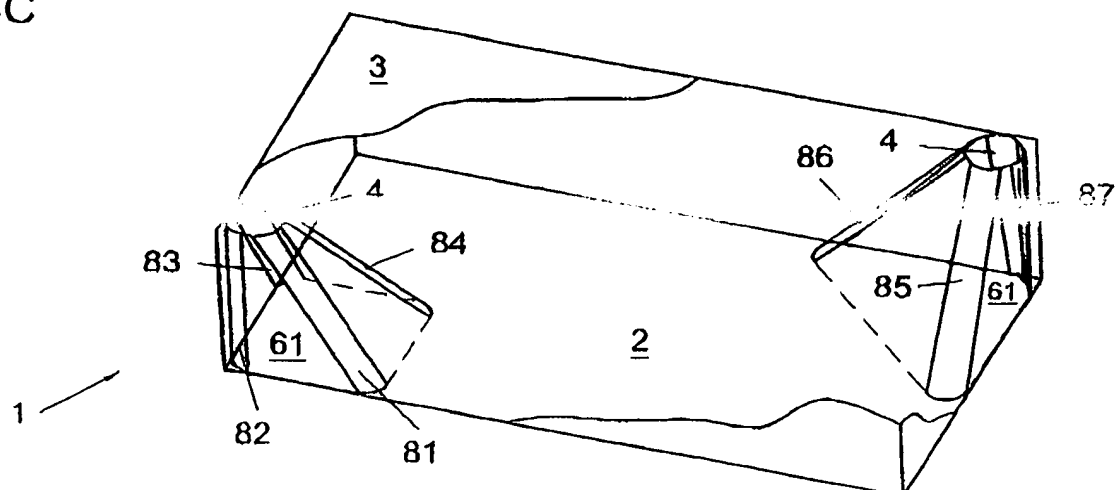


Fig. 4C



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Fig. 5

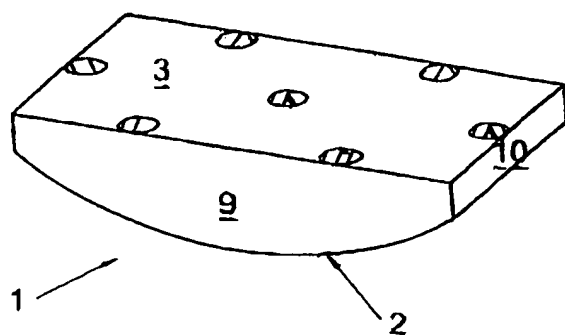


Fig. 6

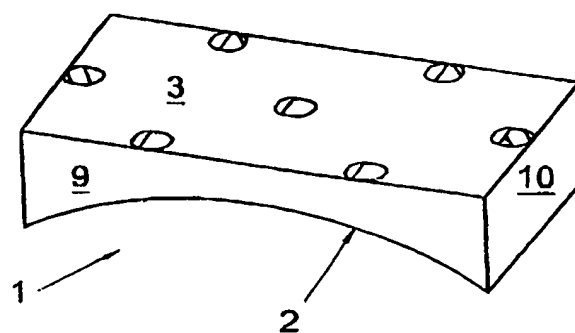
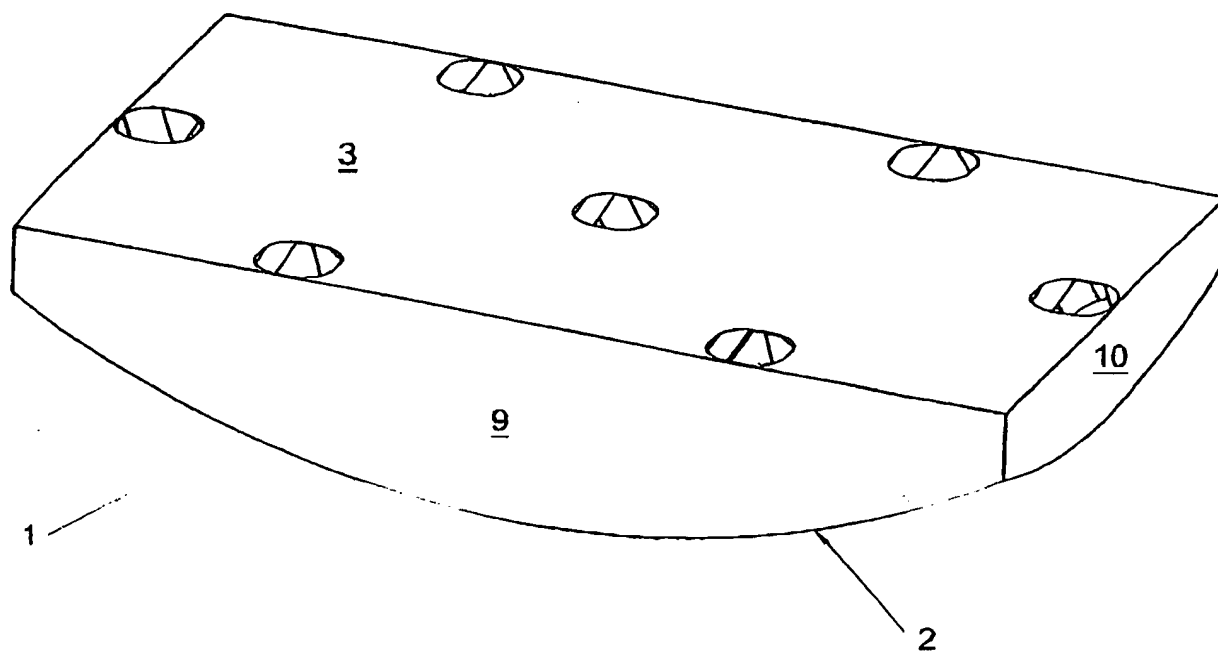


Fig. 7



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Fig. 8A

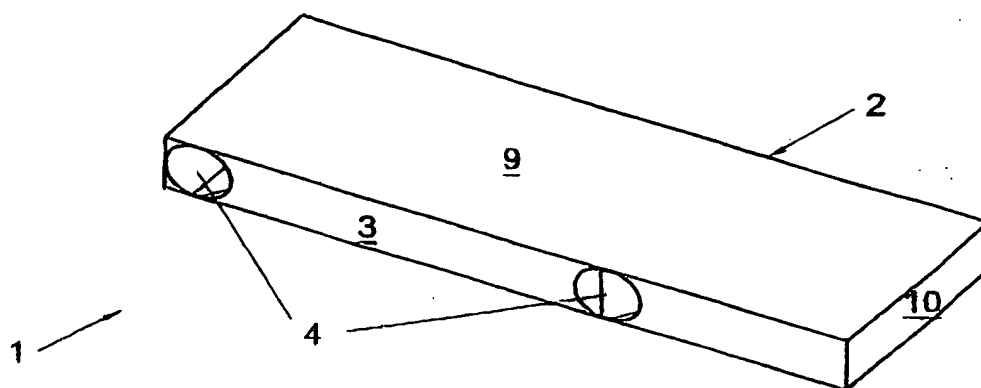
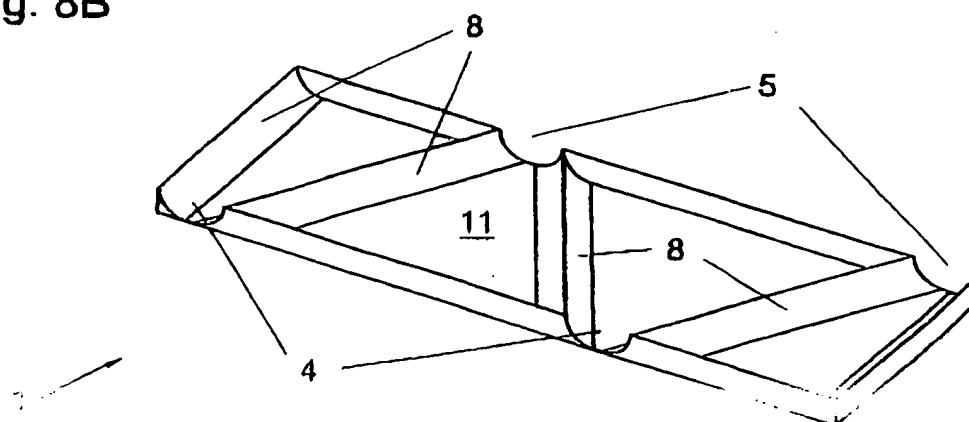


Fig. 8B



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Fig. 9A

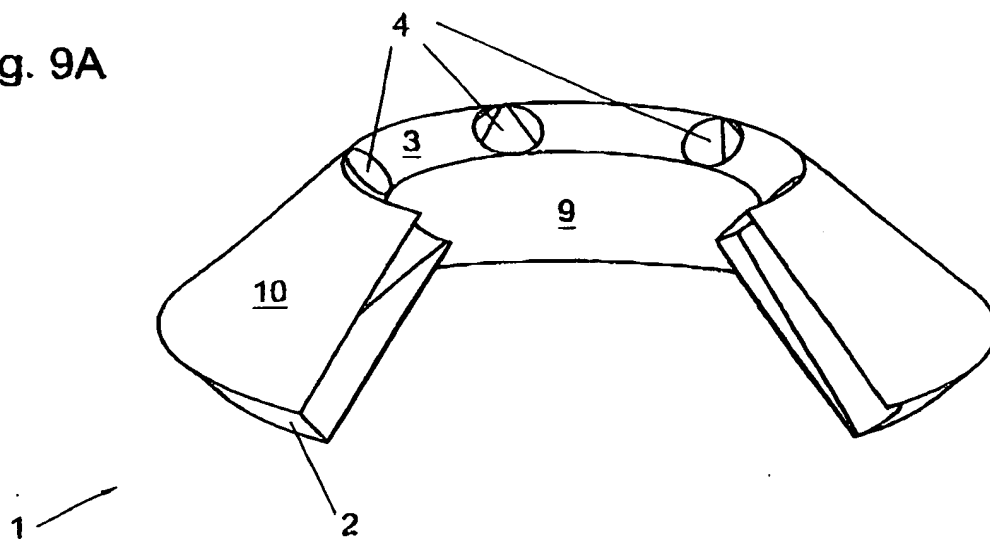
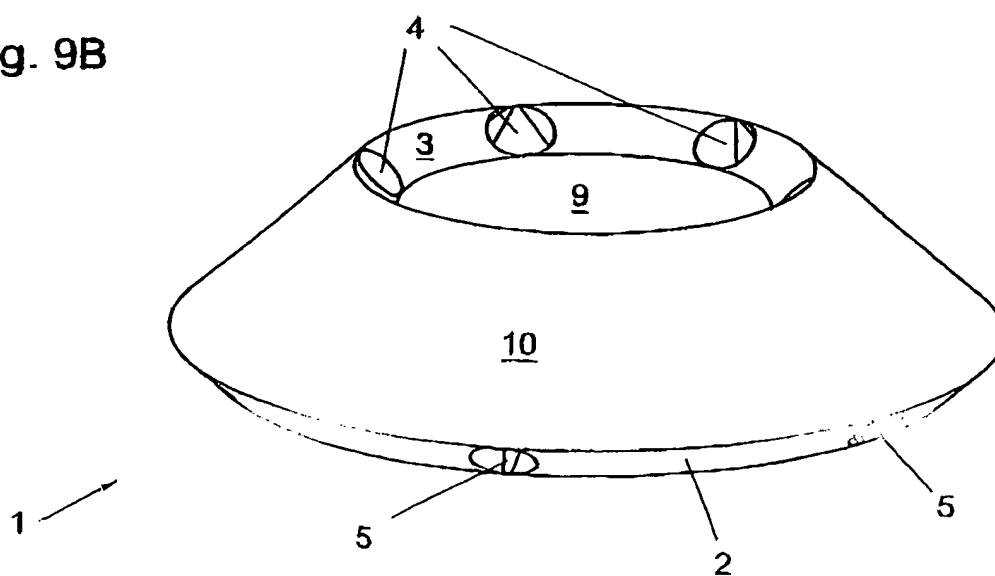


Fig. 9B

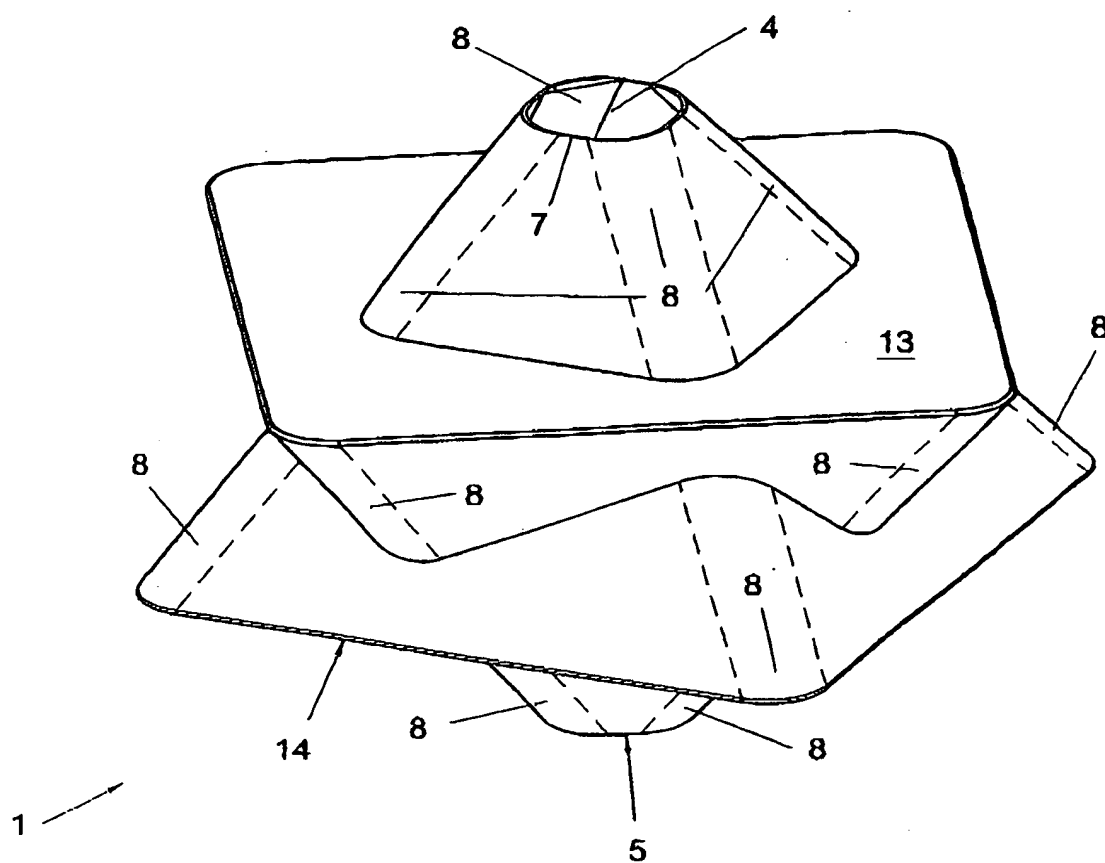


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Fig. 10

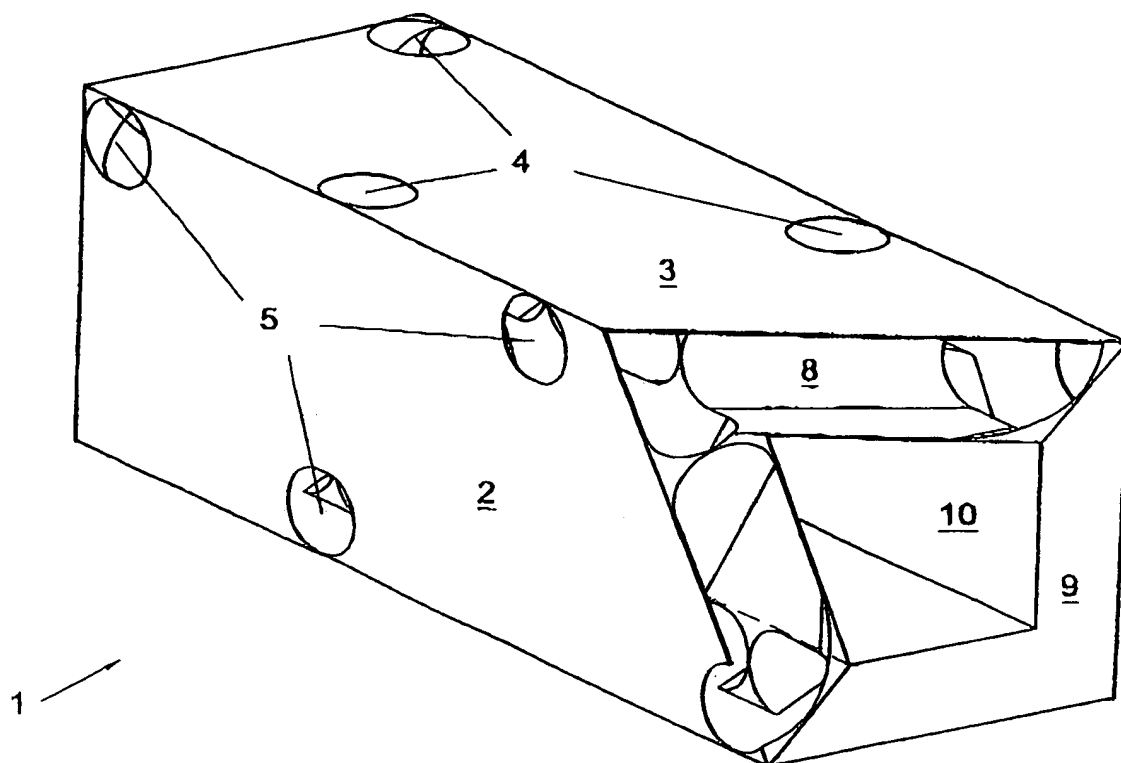


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Fig. 11



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Fig. 12A

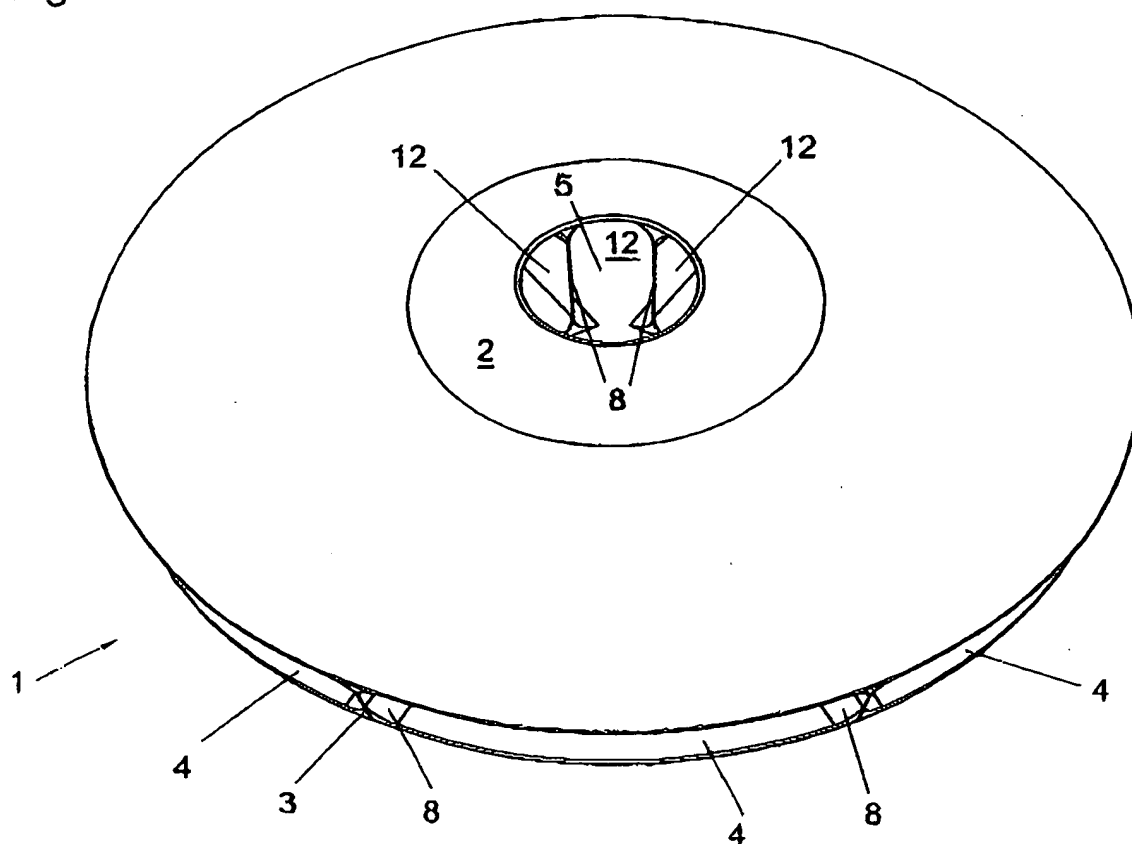
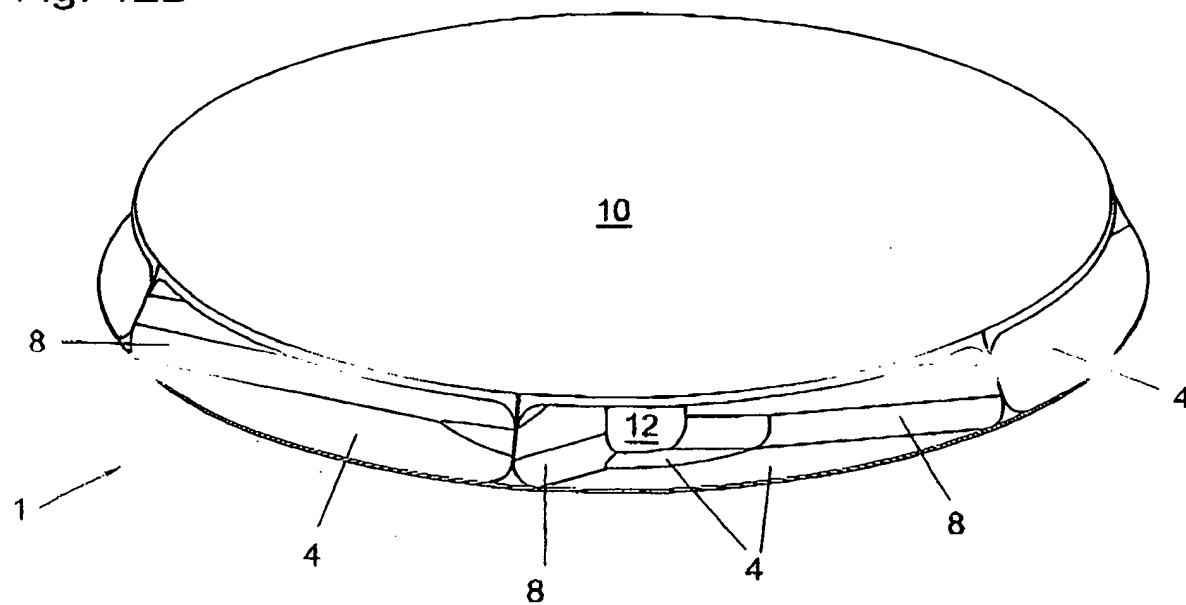


Fig. 12B

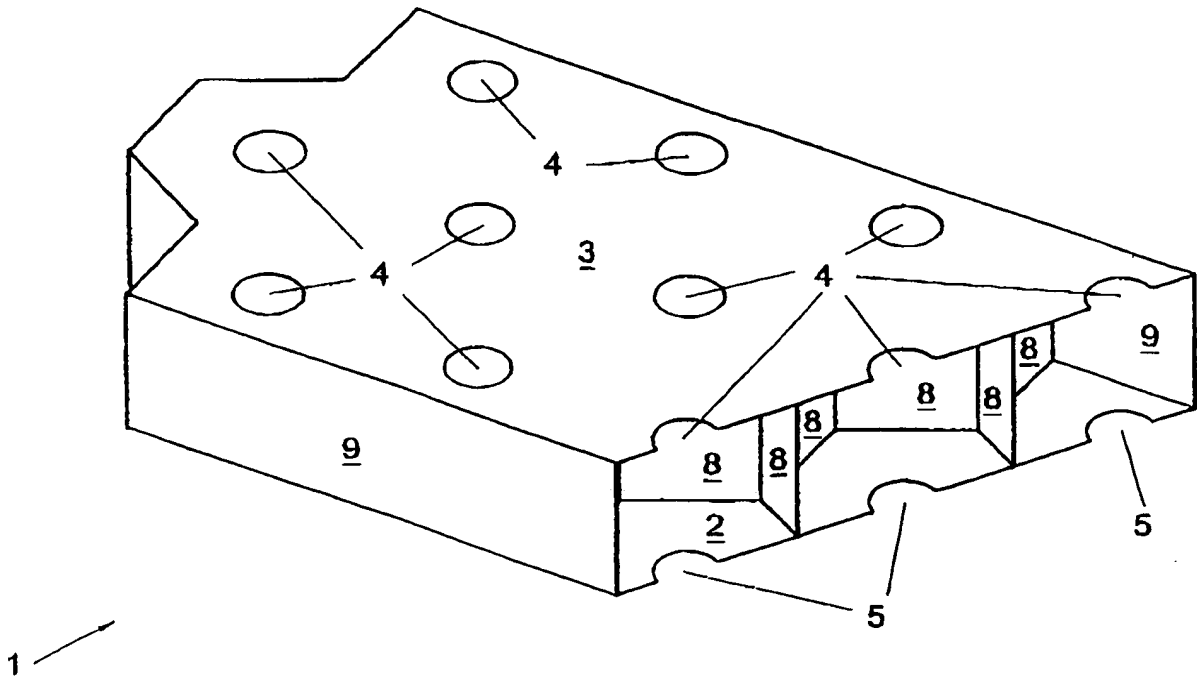


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Fig. 13

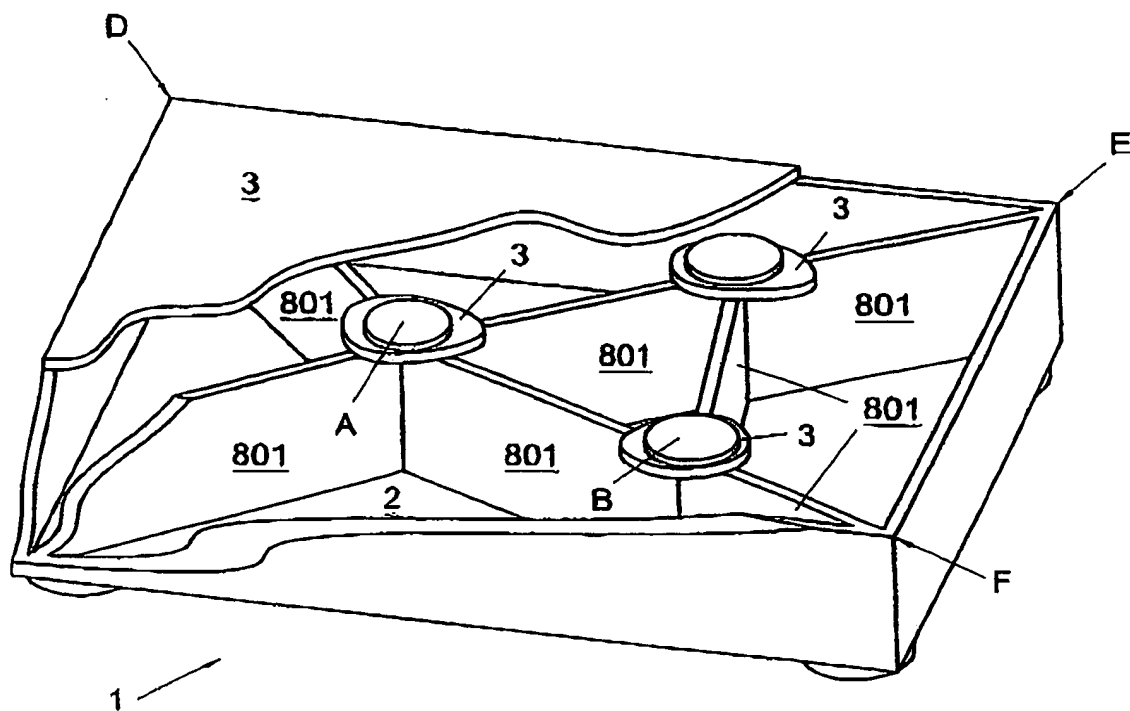


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Fig. 14



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Fig. 16A

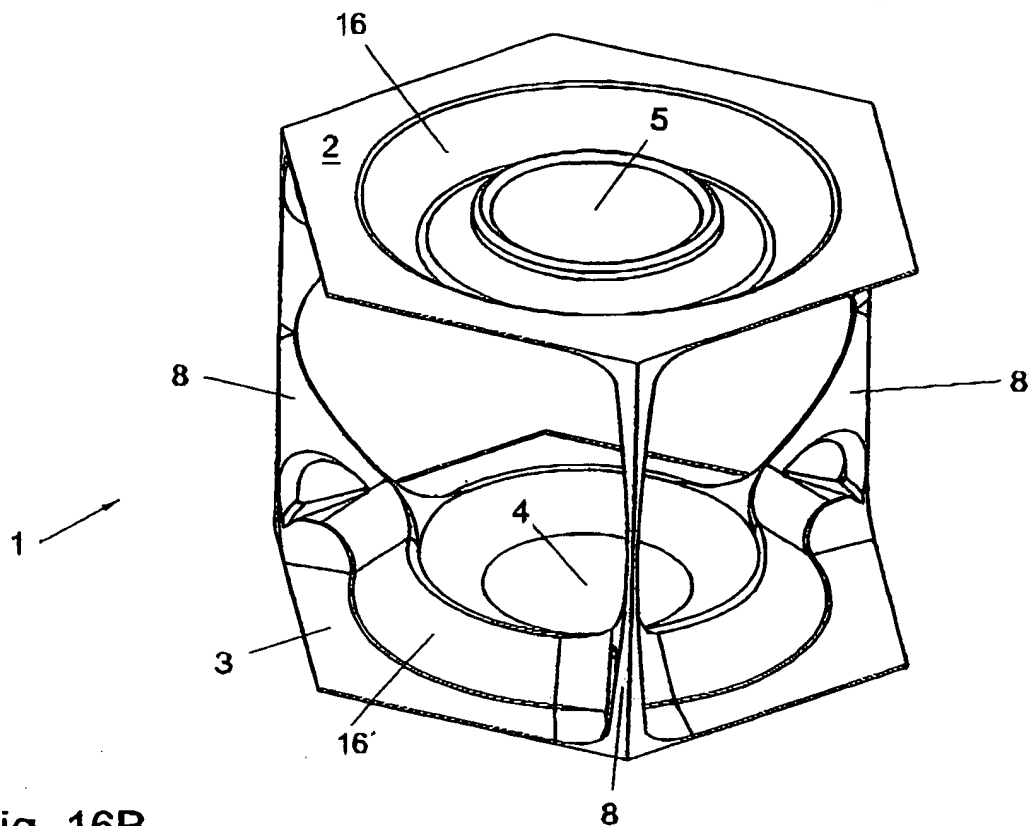
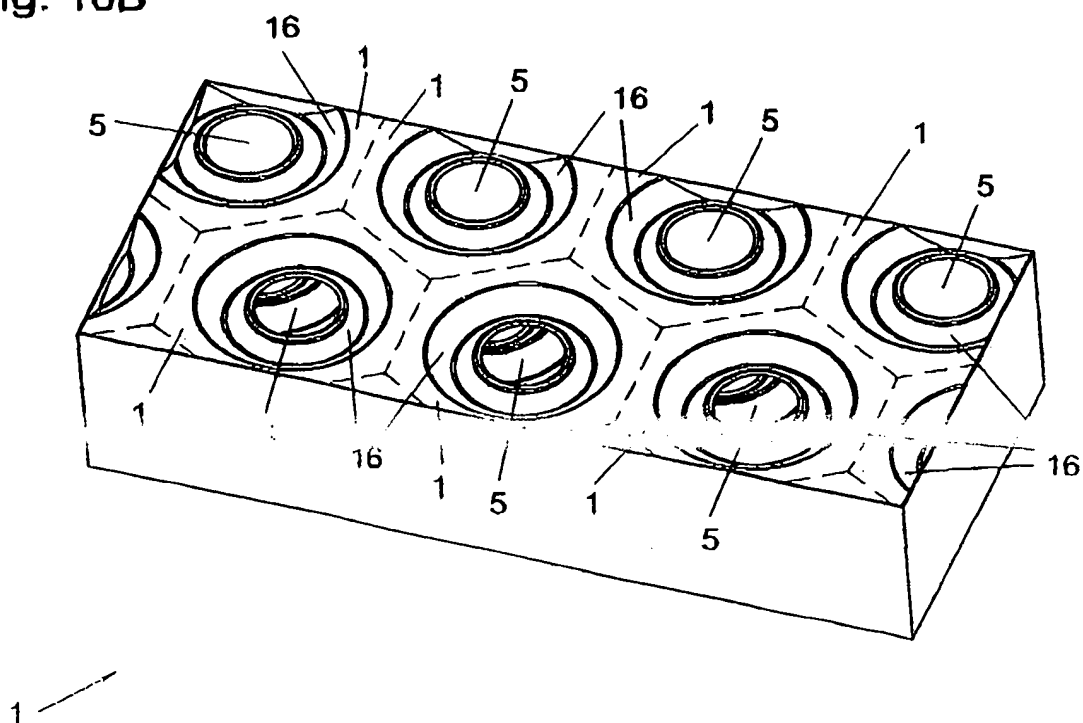


Fig. 16B

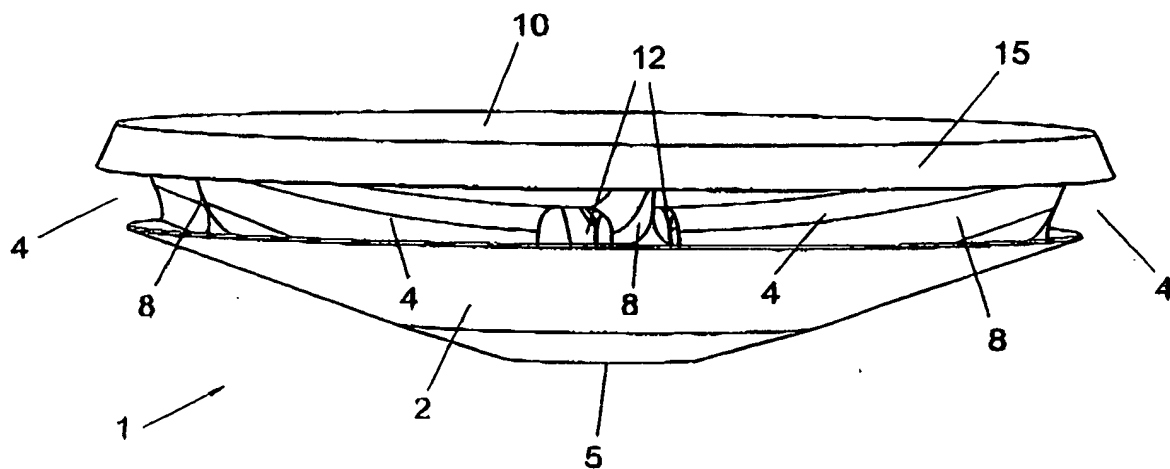


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Fig. 17



INTERNATIONAL SEARCH REPORT

PCT/NL 03/00731

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 602B7/1B2

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 602B B23Q 601N

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

INSPEC, WPI Data, PAJ, EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 6 176 588 B1 (LINDER MICHAEL W ET AL) 23 January 2001 (2001-01-23) column 3, line 7 -column 5, line 60; figures 1-4	1,3,5,9, 11, 13-15, 24,26, 27,29
A	US 4 678 293 A (JACQUES PASERI) 7 July 1987 (1987-07-07) column 2, line 5 - line 68; figures 1-3	1,24,26, 27,29
A	US 5 669 867 A (HOPPE GERD) 23 September 1997 (1997-09-23) cited in the application claim 1	1,24, 26-29

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☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

A document defining the general state of the art which is not considered to be of particular relevance

E earlier document but published on or after the international filing date

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Other means

P document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document, such combination being obvious to a person skilled in the art.

A document member of the same patent family

Date of the actual completion of the international search

2 March 2004

Date of mailing of the international search report

12/03/2004

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Sarneel, A

INTERNATIONAL SEARCH REPORT

PCT/NL 03/00731

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5 076 700 A (DECAPRIO ALFRED R) 31 December 1991 (1991-12-31) column 3, line 34 -column 5, line 10; figure 1	1,24,26, 27,29
A	US 5 227 921 A (BLEIER ZVI ET AL) 13 July 1993 (1993-07-13) claim 1	1,24,26, 27,29

INTERNATIONAL SEARCH REPORT

PCT/NL 03/00731

Patent document cited in search report		Publication date		Patent family member(s)	Publication date
US 6176588	B1	23-01-2001	EP WO	1238302 A1 0144851 A1	11-09-2002 21-06-2001
US 4678293	A	07-07-1987	FR DE DE EP	2588970 A1 3674559 D1 227502 T1 0227502 A1	24-04-1987 31-10-1990 05-11-1987 01-07-1987
US 5669867	A	23-09-1997	DE CN DE EP ES JP	4444614 A1 1131078 A ,B 59502101 D1 0721819 A1 2116666 T3 8243864 A	20-06-1996 18-09-1996 10-06-1998 17-07-1996 16-07-1998 24-09-1996
US 5076700	A	31-12-1991	NONE		
US 5227921	A	13-07-1993	NONE		

INTERNATIONAL SEARCH REPORT

PCT/NL 03/00731

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 602B7/182

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 G02B B23Q G01N

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

INSPEC, WPI Data, PAJ, EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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A	US 4 678 293 A (JACQUES PASERI) 7 July 1987 (1987-07-07) column 2, line 5 - line 68; figures 1-3	1,24,26, 27,29
A	US 5 669 867 A (HOPPE GERD) 23 September 1997 (1997-09-23) cited in the application claim 1	1,24, 26-29
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
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- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *&* document member of the same patent family

Date of the actual completion of the international search

2 March 2004

Date of mailing of the international search report

12/03/2004

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax (+31-70) 340-3016

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Sarneel, A

INTERNATIONAL SEARCH REPORT

PCT/NL 03/00731

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5 076 700 A (DECAPRIO ALFRED R) 31 December 1991 (1991-12-31) column 3, line 34 -column 5, line 10; figure 1 -----	1,24,26, 27,29
A	US 5 227 921 A (BLEIER ZVI ET AL) 13 July 1993 (1993-07-13) claim 1 -----	1,24,26, 27,29

INTERNATIONAL SEARCH REPORT

PCT/NL 03/00731

Patent document cited in search report		Publication date		Patent family member(s)	Publication date
US 6176588	B1	23-01-2001	EP WO	1238302 A1 0144851 A1	11-09-2002 21-06-2001
US 4678293	A	07-07-1987	FR DE DE EP	2588970 A1 3674559 D1 227502 T1 0227502 A1	24-04-1987 31-10-1990 05-11-1987 01-07-1987
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US 5076700	A	31-12-1991	NONE		
US 5227921	A	13-07-1993	NONE		

PCT



REC'D 28 JAN 2005

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INTERNATIONAL PRELIMINARY EXAMINATION REPORT
(PCT Article 36 and Rule 70)

Applicant's or agent's file reference P60777PC00		FOR FURTHER ACTION See Notification of Transmittal of International Preliminary Examination Report (Form PCT/IPEA/416)	
International application No. PCT/NL 03/00731	International filing date (day/month/year) 28.10.2003	Priority date (day/month/year) 29.10.2002	
International Patent Classification (IPC) or both national classification and IPC G02B7/182			
Applicant STICHTING ASTRON et al.			

1.	This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.
2.	<p>This REPORT consists of a total of <u>5</u> sheets, including this cover sheet.</p> <p><input type="checkbox"/> This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).</p> <p>These annexes consist of a total of sheets.</p>
3.	<p>This report contains indications relating to the following items:</p> <p>I <input checked="" type="checkbox"/> Basis of the opinion</p> <p>II <input type="checkbox"/> Priority</p> <p>III <input type="checkbox"/> Non-establishment of opinion with regard to novelty, inventive step and industrial applicability</p> <p>IV <input type="checkbox"/> Lack of unity of invention</p> <p>V <input checked="" type="checkbox"/> Reasoned statement under Rule 66.2(a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement</p> <p>VI <input type="checkbox"/> Certain documents cited</p> <p>VII <input type="checkbox"/> Certain defects in the international application</p> <p>VIII <input type="checkbox"/> Certain observations on the international application</p>

Date of submission of the demand 27.05.2004	Date of completion of this report 01.02.2005
Name and mailing address of the International preliminary examining authority:  European Patent Office - P.B. 5818 Patentlaan 2 NL-2280 HV Rijswijk - Pays Bas Tel. +31 70 340 - 2040 Tx: 31 651 epo nl Fax: +31 70 340 - 3016	Authorized Officer Sarneel, A Telephone No. +31 70 340-3018 

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. **PCT/NL 03/00731**

I. Basis of the report

1. With regard to the **elements** of the international application (*Replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report since they do not contain amendments (Rules 70.16 and 70.17)*):

Description, Pages

1-17 as originally filed

Claims, Numbers

1-29 as originally filed

Drawings, Sheets

1/14-14/14 as originally filed

2. With regard to the **language**, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
- ☐ the language of publication of the international application (under Rule 48.3(b)).
- ☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).

3. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:

- ☐ contained in the international application in written form.
- ☐ filed together with the international application in computer readable form.
- ☐ furnished subsequently to this Authority in written form.
- ☐ furnished subsequently to this Authority in computer readable form.
- ☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
- ☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

4. The amendments have resulted in the cancellation of:

- ☐ the description, pages:
- ☐ the claims, Nos.:
- ☐ the drawings, sheets:

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/NL 03/00731

5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed (Rule 70.2(c)).

(Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report.)

6. Additional observations, if necessary:

V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty (N)	Yes: Claims	1-29
	No: Claims	
Inventive step (IS)	Yes: Claims	1-29
	No: Claims	
Industrial applicability (IA)	Yes: Claims	1-29
	No: Claims	

2. Citations and explanations

see separate sheet

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/NL 03/00731

Re Item V

Reasoned statement with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Reference is made to the following document/s/
D1: US-A-6 176 588
D2: EP-A-227 502
2. Document D1 discloses a lightweight mirror blank having a matrix of cell walls defining an array of cells having an opening at both sides of the mirror blank. (see figure 2 and corresponding text).

Consequently, said mirror blank comprises:

- at least a first side (front surface (14)) with at least one first opening;
- at least one second side (back surface (16)) with at least one second opening;
- at least one first space between the first and second side which is connected to the first opening (the cell space near the opening to the front surface (14));
- at least one second space between the first and the second side which is connected to the second opening (the cell space near the opening to the back surface (16)); and
- at least one connection between the first side and the second side which defines the walls of the spaces at least partly (the cell walls);
- wherein the first side, the second side and the connection form one integral whole.

Therefore, the construction element that is specified in claim 1 differs from the one known from D1 in that at least one of the spaces narrows towards the opening connected to it.

Because of this feature, a more rigid construction element is obtained.

3. From D2, a mirror blank is known comprising cavities that are obtained by machining the blank from one side. The openings to this side are narrower than the cavities, so the spaces obtained narrow towards the openings.

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/NL 03/00731

Although both D1 and D2 relate to the manufacturing of lightweight mirror blanks, the methods used are completely different: D1 is made by extrusion and firing of a ceramic compound, whereas in D2, a substrate is machined with a milling device. Moreover, the dimensions of the cavities obtained are completely different. For these reasons, it is unlikely that a skilled person would combine D1 and D2 in order to arrive at the subject-matter of claim 1, which is therefore considered to be novel and inventive.

4. Dependent claims 2-25 specify additional features and are also allowable. For similar reasons, the claims relating to a method, apparatus and data carrier to manufacture the construction element are allowable.

PATENT COOPERATION TREATY

Rec'd PCT/PTO 27 APR 2005

From the
INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

To:

Winckels, J.H.F.
c/o VEREENIGDE
Nieuwe Parklaan 97

NL-2587 BN The Hague

PAYS-BAS

29-04-05 (gum)

- 3 FEB 2005

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PCT FEB 2005

NOTIFICATION OF TRANSMITTAL OF
THE INTERNATIONAL PRELIMINARY
EXAMINATION REPORT
(PCT Rule 71.1)Date of mailing
(day/month/year)

01.02.2005

Applicant's or agent's file reference

P00777PC00

IMPORTANT NOTIFICATION

International application No.

PCT/NL 03/00731

International filing date (day/month/year)

28.10.2003

Priority date (day/month/year)

29.10.2002

Applicant

STICHTING ASTRON et al.

1. The applicant is hereby notified that this International Preliminary Examining Authority transmits herewith the international preliminary examination report and its annexes, if any, established on the international application.
2. A copy of the report and its annexes, if any, is being transmitted to the International Bureau for communication to all the elected Offices.
3. Where required by any of the elected Offices, the International Bureau will prepare an English translation of the report (but not of any annexes) and will transmit such translation to those Offices.

4. REMINDER

The applicant must enter the national phase before each elected Office by performing certain acts (filing translations and paying national fees) within 30 months from the priority date (or later in some Offices) (Article 39(1)) (see also the reminder sent by the International Bureau with Form PCT/IB301).

Where a translation of the international application must be furnished to an elected Office, that translation must contain a translation of any annexes to the international preliminary examination report. It is the applicant's responsibility to prepare and furnish such translation directly to each elected Office concerned.

For further details on the applicable time limits and requirements of the elected Offices, see Volume II of the PCT Applicant's Guide.

The applicant's attention is drawn to Article 33(5), which provides that the criteria of novelty, inventive step and industrial applicability described in Article 33(2) to (4) merely serve the purposes of international preliminary examination and that "any Contracting State may apply additional or different criteria for the purposes of deciding whether, in that State, the claimed inventions is patentable or not" (see also Article 27(5)). Such additional criteria may relate, for example, to exemptions from patentability, requirements for enabling disclosure, clarity and support for the claims.

Name and mailing address of the international
preliminary examining authority:

European Patent Office - P.B. 5818 Patentlaan 2
NL-2280 HV Rijswijk - Pays Bas
Tel. +31 70 340 - 2040 Tx: 31 651 epo nl
Fax: +31 70 340 - 3016

Authorized Officer

Pozzi, C



Tel. +31 70 340-3260



PATENT COOPERATION TREATY

PCT

INTERNATIONAL PRELIMINARY EXAMINATION REPORT
(PCT Article 36 and Rule 70)

Applicant's or agent's file reference P60777PC00		FOR FURTHER ACTION See Notification of Transmittal of International Preliminary Examination Report (Form PCT/PEA416)	
International application No. PCT/NL 03/00731	International filing date (day/month/year) 28.10.2003	Priority date (day/month/year) 29.10.2002	
International Patent Classification (IPC) or both national classification and IPC G02B7/182			
Applicant STICHTING ASTRON et al.			
<p>1. This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.</p> <p>2. This REPORT consists of a total of 11 sheets, including this cover sheet.</p> <p><input type="checkbox"/> This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).</p> <p>These annexes consist of a total of sheets.</p>			
<p>3. This report contains indications relating to the following items:</p> <p>I <input checked="" type="checkbox"/> Basis of the opinion</p> <p>II <input type="checkbox"/> Priority</p> <p>III <input type="checkbox"/> Non-establishment of opinion with regard to novelty, inventive step and industrial applicability</p> <p>IV <input type="checkbox"/> Lack of unity of invention</p> <p>V <input checked="" type="checkbox"/> Reasoned statement under Rule 66.2(a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement</p> <p>VI <input type="checkbox"/> Certain documents cited</p> <p>VII <input type="checkbox"/> Certain defects in the international application</p> <p>VIII <input type="checkbox"/> Certain observations on the international application</p>			
Date of submission of the demand 27.05.2004		Date of completion of this report 01.02.2005	
Name and mailing address of the International preliminary examining authority:  European Patent Office - P.B. 5818 Patentlaan 2 NL-2280 HV Rijswijk - Pays Bas Tel. +31 70 340 - 2040 Tx: 31 651 epo nl Fax: +31 70 340 - 3016		Authorized Officer Sameel, A Telephone No. +31 70 340-3018 	

10/532846

JC20 Rec'd PCT/PTO 27 APR 2005

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/NL 03/00731

I. Basis of the report

1. With regard to the **elements** of the international application (*Replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report since they do not contain amendments (Rules 70.16 and 70.17)*):

Description, Pages

1-17 as originally filed

Claims, Numbers

1-29 as originally filed

Drawings, Sheets

1/14-14/14 as originally filed

2. With regard to the **language**, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
 - ☐ the language of publication of the international application (under Rule 48.3(b)).
 - ☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).
3. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:
- ☐ contained in the international application in written form.
 - ☐ filed together with the international application in computer readable form.
 - ☐ furnished subsequently to this Authority in written form.
 - ☐ furnished subsequently to this Authority in computer readable form.
 - ☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
 - ☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.
4. The amendments have resulted in the cancellation of:
- ☐ the description, pages:
 - ☐ the claims, Nos.:
 - ☐ the drawings, sheets:

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**International application No. **PCT/NL 03/00731**

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see separate sheet

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/NL 03/00731

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